



Dart Aerospace Ltd.
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Canada

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20NR-86
Job Sheet 193869



Part No: 20NR-86

Job Qty: 1 pcs

Part Name: Dual Hook Cage Frame



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 4/23/19

Job Tracking No:

Due Date: 5/10/19

Created By: Eric Larocque

Type: SOLD

Description:

Note: DWG 20NR-86 Rev.1 IPP Rev. A 19.02.11 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Large Fab - Welded Assy-1	1 pcs	5/10/19	5/10/19	0.00	1.00	Large Fab - 1		
							Large Fab - 10		
							Large Fab - 2		
							Large Fab - 3		
							Large Fab - 4		
							Large Fab - 5		
							Large Fab - 6		
							Large Fab - 7		
							Large Fab - 8		
115	QC 9	1 pcs	5/10/19	5/10/19	0.00	0.00	Large Fab - 9		MAY 23 2019
							QC 9 - 10		
							QC 9 - 18	DAS	
							QC 9 - 24	24	
							QC 9 - 43	9-89	
							QC 9 - 50		
120	QC 5	1 pcs	5/10/19	5/10/19	0.00	0.00	QC 9 - 9		MAY 23 2019
							QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22	DAS	
							QC 5 - 24	24	
							QC 5 - 3	9-89	
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		



Container No: S183690



Part: 20NR-86

Job No: 193869

Serial No/Batch: S183690

Revision: 1

Inspector:

Exp Date:

Instructions:

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Date: 05/23/19

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130 Powdercoat - 6 Fire Red - B4B	1 pcs	5/10/19	0.00 0.00	QC 5 - 30	
				Powdercoat - 1 - B4B	
				Powdercoat - 2 - B4B	
				Powdercoat - 3 - B4B	
140 QC 3	1 pcs	5/10/19	0.00 0.00	Powdercoat - 4 - B4B	BR 19-5-24
				QC 3 - 10	
				QC 3 - 13	
				QC 3 - 15	
				QC 3 - 17	
				QC 3 - 18	
				QC 3 - 2	
				QC 3 - 28	
				QC 3 - 3	
				QC 3 - 30	
				QC 3 - 34	AT VM BR 19-5-24
				QC 3 - 36	
				QC 3 - 41	
				QC 3 - 51	
				QC 3 - 58	
				QC 3 - 59	
				QC 3 - 68	
180 Packaging 3-1 - Stock - B4B	1 pcs	5/10/19	0.00 0.00	QC 3 - 9	
				Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
190 QC 21 - SA	1 pcs	5/10/19	0.00 0.00	QC 21 - SA - 21	

QC 21 - SA - 70

QC 21 - SA - 53

Part Op 110 - 1-Weld as per DWG. Use 8/20NR jig to assemble. 3/8" welds on all parts. See note 1 and 2.
 Descriptions: 115 - (QC9- Inspect visual per QSI004- Fusion Welds)

120 - (QC5- Inspect part completeness to step on W/O)

130 - Fire Red(Ref:4.3.5.10) per QSI005 4.3) Mask as per note 8. START TIME: 8:50 OVEN TEMPERATURE: 575°
 FINISH TIME: 9:05 *NIA* *129223*

140 - (QC3- Inspect Part Finish)

180 - (Identify as per dwg & Stock Location: _____)

190 - (QC21- Final Inspection - Work Order Release)

6A-TBD

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
20NR-119-1	Bracket	2 pcs (2 ea)	110-Large Fab - Welded Assy-1	5176244 → 2
20NR-119-10	Support Tubing	2 pcs (2 ea)	110-Large Fab - Welded Assy-1	5173610 → 2
20NR-119-2-DHC	DHC Back Plate	1 pcs (1 ea)	110-Large Fab - Welded Assy-1	5168407 → 1
20NR-119-3P	Feeder Support Bracket	4 pcs (4 ea)	110-Large Fab - Welded Assy-1	5029459 → 4
20NR-119-4	Left Top Feeder	2 pcs (2 ea)	110-Large Fab - Welded Assy-1	5168401 → 2
20NR-119-4B	Bottom Left Feeder	2 pcs (2 ea)	110-Large Fab - Welded Assy-1	5164329 → 2
20NR-119-5	Top Right Feeder	2 pcs (2 ea)	110-Large Fab - Welded Assy-1	5164352 → 2
20NR-119-5B	Bottom Right Feeder	2 pcs (2 ea)	110-Large Fab - Welded Assy-1	5164335 → 2
20NR-119-6	Upper Funnel Guide	4 pcs (4 ea)	110-Large Fab - Welded Assy-1	5168821 → 4
20NR-119-7	Lower Funnel Guide	4 pcs (4 ea)	110-Large Fab - Welded Assy-1	5170980 → 4
20NR-119-8	Front Support	4 pcs (4 ea)	110-Large Fab - Welded Assy-1	5164256 → 4
20NR-119-9-DHC	Guard	1 pcs (1 ea)	110-Large Fab - Welded Assy-1	5173554 → 1
20NR-120-5	Funnel Tab	2 pcs (2 ea)	110-Large Fab - Welded Assy-1	5164391 → 2

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Large Fab - Welded Assy-1	20NR-119-1	2	23	0
	20NR-119-10	2	8	0
	20NR-119-2-DHC	1	4	0
	20NR-119-3P	4	5	0
	20NR-119-4	2	10	0
	20NR-119-4B	2	8	0
	20NR-119-5	2	10	0
	20NR-119-5B	2	8	0
	20NR-119-6	4	16	0
	20NR-119-7	4	16	0
	20NR-119-8	4	10	0
	20NR-119-9-DHC	1	4	0
	20NR-120-5	2	11	0

Part Specifications

Specifications could not be found.

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